

Date: Wednesday, 14/05/2008 11:23:27 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER	
Job Number	: 39261		Part Number	: D30661	
Estimate Number	: 10383		Drawing Number	: D3066 REV.B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 14/05/2008 S.O. No. :		Drawing Revision	: B	
Prsh Rev.	: NC		Material	:	
First Issue	: 14/05/2008 Type : SMALL /MED FAB		Due Date	: 30/05/2008 Qty: 120 Um: Each	
Previous Run	: 38925				
Written By	:				
Checked & Approved By	: JUD 28.5.14				
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:B Now M6061-T6 06-06-23 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
		Comment: Qty.: 0.0992 sf(s)/Unit Total: 11.9070 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) Batch: 107904 HB 8-5-23
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3066 Dwg Rev: B HB 8-5-23 Prog Rev: B
		2-Deburr if necessary HB 8-5-23
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE HB 8-5-23
4.0	QC8	SECOND CHECK QSP0195 08/05/26 counted
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 HB 08-05-26
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 39261

Part Number: D30661

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

FL 08/05/26

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PAT C-

PC05/26 (106)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27 AF

Job Completion



MF 08-05-27

Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39261
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	AB	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	8-5-23	Date:	08/05/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

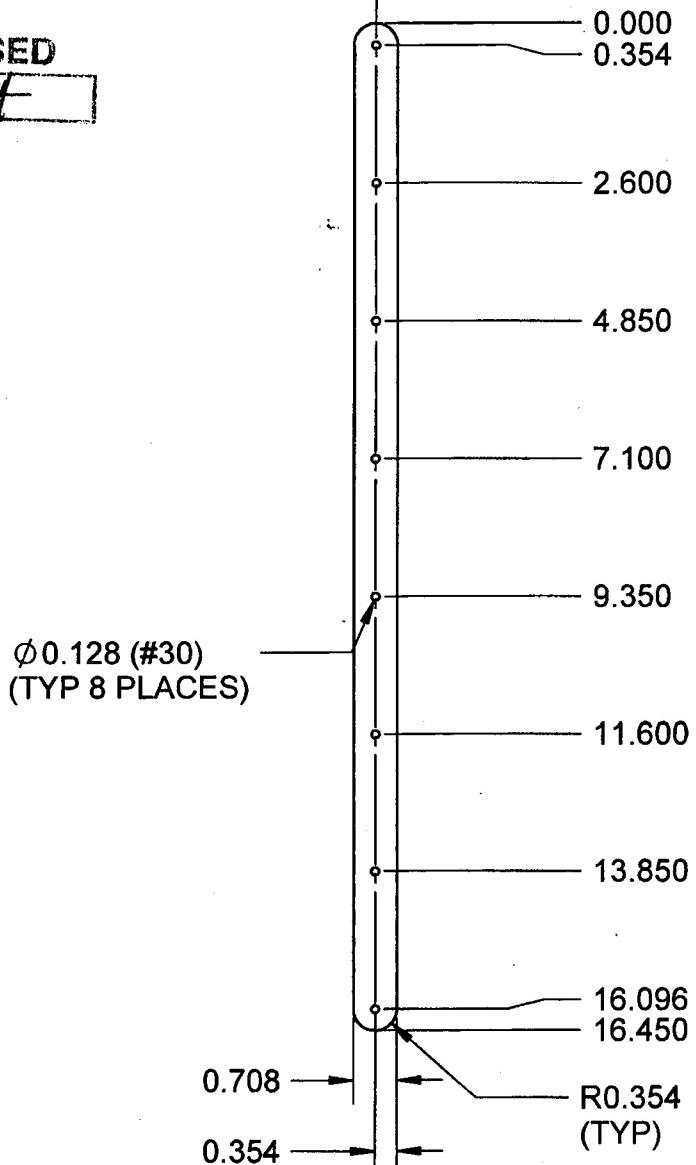
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>Pt</i>	APPROVED <i>SM</i>	DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE SPACER	SCALE 1:3	
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED*6.6.20 -f-***D3066-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
 - 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 - 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 4) PART IS SYMMETRIC ABOUT CENTERLINE
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE IN INCHES
- SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39261

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